

Date: Monday, 2/11/2008 2:14:26 PM  
User: Kim Johnston

## Process Sheet

SPL/7

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE KIT FOR D206-642-512	
Job Number	: 37361 - 1		Part Number	: K642 512	
Estimate Number	: 12894		Drawing Number	: N/A	
P.O. Number	:		Project Number	: N/A	
This Issue	: 2/11/2008	S.O. No. :	Drawing Revision	: N/A	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type : LANDING GEAR	Due Date	: 2/28/2008	Qty: 1/8 Um: Each
Previous Run	: 36022				
Written By	:	10			
Checked & Approved By	:	10/08 02 11			
Comment	: Est Rev.A 05.06.07 new issue EC				
	Est. Rev.B 05.02.08, Per ECN1080P				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		Comment: DOCUMENT CONTROL Photo copy bluefile and create labels per PPP K642-512 CHG003	8/2/2 JP
2.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
3.0	D206648013	GHW Kit	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)	
		Pick: Qty Part Number Description Batch	
		1 D206-648-013 GHW Kit B37365	AS 08/03/27 (x8)
4.0	D2652	Bushing	
		Comment: Qty.: 16.0000 Each(s)/Unit Total : 128.0000 Each(s)	
		Pick: Qty Part Number Description Batch	
		16 D2652 Bushing B37366	AS 08/03/27 (x8)
5.0	D2712	Set Screw	
		Comment: Qty.: 10.0000 Each(s)/Unit Total : 80.0000 Each(s)	X There are 47 in Box 245 in comp. wait let you take it out
		Pick: Qty Part Number Description Batch	
		10 D2712 Set Screw B360186 X47 B34628 X33	AS 08/03/27 (x8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SADDLE KIT FOR D206-642-512

Job Number: 37361

Part Number: K642 512

Job Number:



Seq. #: Machine Or Operation:

Description :

HTT 6.0

D29322



206 Saddle Right side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2932-2

Saddle

36875x7- B35477x1

\* New batch

AS 08/03/27 (x8)

HTT 7.0

D29332



206 Saddle Right



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2933-2

Saddle

B35280

AS 08/03/27 (x8)

HTT 8.0

D2934



Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2934

Saddle Spacer

37368

AS 08/03/27 (x8)

HTT 9.0

D2935



Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2935

Saddle Spacer

36142

AS 08/03/27 (x8)

HTT 10.0

D29382



206 Saddle Right side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2938-2

Saddle

B334732 x6 B36876x2

AS 08/03/27 (x8)

HTT 11.0

D29392



206 Saddle Right Side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2939-2

Saddle

B36877x1 B36877x6

AS 08/04/02 (x8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-512

Job Number: 37361

Part Number: K642 512

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0

D33963

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3396-3

Spacer

B360336

AS 08/03/27 X8

13.0

D3407043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3407-043

Tow Ring

B35510

AS 08/03/27 X8

14.0

D34561

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3456-1

Washer

B33276

AS 08/03/27 X8

15.0

D34571

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3457-1

Washer

B337123

AS 08/03/27 X8

16.0

AN3C35A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C35A

Bolt

M106541

there was  
20 in Box

AS 08/03/27 X8

17.0

AN3C36A

BOLT



Comment: Qty.: 9.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

9 AN3C36A

Bolt

M106541

AS 08/03/27 X8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-512

Job Number: 37361

Part Number: K642 512

Job Number:



Seq. #: Machine Or Operation:

Description :

~~18.0~~

AN3C41A



BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN3C41A

Bolt

M106176 x20 M107463 x44 AS 08/03/27 (8)

~~19.0~~

AN4C6A



Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 AN4C6A

Bolt

M106519.

AS 08/03/27 (8)

~~20.0~~

AN5C11A



Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN5C11A

Bolt

M107013

AS 08/03/27 (8)

~~21.0~~

AN5C12A



Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C12A

Bolt

M106516 . x17 M107328 x15 AS 08/03/27 (8)

(32x) 8/4/2 SC

~~22.0~~

AN5C13A



Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C13A

Bolt

M107615

(32x) 8/4/2 SC

~~23.0~~

AN5C15A



Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C15A

Bolt

M105125

AS 08/03/27 (8)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services	Drawing Name: SADDLE KIT FOR D206-642-512
Job Number: 37361	Part Number: K642 512
Job Number:	
Seq. #: Machine Or Operation:	Description :
29.0 AN960C516L	WASHER
Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)	
Pick:	
Qty Part Number	Description
8 AN960C516L	Washer
30.0 MS210433	Nut
Comment: Qty.: 20.0000 Each(s)/Unit Total : 160.0000 Each(s)	
Pick:	
Qty Part Number	Description
20 MS21043-3	Nut
31.0 MS210434	Nut
Comment: Qty.: 13.0000 Each(s)/Unit Total : 104.0000 Each(s)	
Pick:	
Qty Part Number	Description
13 MS21043-4	Nut
32.0 MS210435	Nut
Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)	
Pick:	
Qty Part Number	Description
4 MS21043-5Nut	
33.0 D36721	PHENOLIC WASHER
Comment: Qty.: 24.0000 Each(s)/Unit Total : 192.0000 Each(s)	
PHENOLIC WASHER	
34.0 D36723	PHENOLIC WASHER
Comment: Qty.: 24.0000 Each(s)/Unit Total : 192.0000 Each(s)	
PHENOLIC WASHER	
There is still a batch #34471 in Box that is not in comp. Qty = 77.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services	Drawing Name: SADDLE KIT FOR D206-642-512	
Job Number: 37361	Part Number: K642 512	
Job Number:		
Seq. #: 35.0	Machine Or Operation: D36725	Description : PHENOLIC WASHER
Comment: Qty.: 16.0000 Each(s)/Unit Total : 128.0000 Each(s) PHENOLIC WASHER	B35521	AS 08/03/26 (X8)
36.0	D36727	PHENOLIC WASHER
Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s) PHENOLIC WASHER	B35522	AS 08/03/26 (X8)
37.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
Comment: INSPECT 100% KITS FOR COMPLETENESS		S 08/03/26 (X7)
38.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP K642-512 CHG003 Location: _____		8/4/2 56 (X8)
39.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		08/04/08 (X8)
Job Completion		mF 08-04-03
		W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries